

January-25-12 3:10:50 PM

79413

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Hinge Half, Base

Start Date: 25/01/2012 **Start Qty:** 18.00

18

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 18.00

18

Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/25 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

**Insp.
Stamp**

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.00" LONG

110

0.00.

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV:

DWG REV:

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79413

79413

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Page 2

Item ID: D4016-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Half, Base
 Start Date: 25/01/2012 Start Qty: 18.00 ***18*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 18.00 ***18*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		121215		18			
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		12102106		19			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		12102106		19x			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

79413

Page 3

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 25/01/2012 **Start Qty:** 18.00

18

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 18.00

18

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

M.C.J 12/02/06 ~~98~~

1012-02-4
(19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 79413

79413

Parent Item: D4016-1

D4016-1

Parent Item Name: Hinge Half, Base

Start Date: 25/01/2012

Required Date: 31/01/2012

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	12.8736	0.08	1.44			

M304B1 000X1 000

**

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

12.8736

113290

1.047

117130

0.7316

118844

11.095

1.523 F.K 12/02/01

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOTICE
ORDER
79413 M.L.J
12/01/25



RELEASED
2010-02-16
md

A	NEW ISSUE		JPH	10.01.29
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4016 TITLE BASKET HINGE		
DRAWN	AJS			
CHECKED	<i>CS</i>			REV.
MFG. APPR.	<i>KS</i>			SHEET 1 OF
APPROVED	<i>MD</i>			SCALE
DE APPR.	<i>HT</i>			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

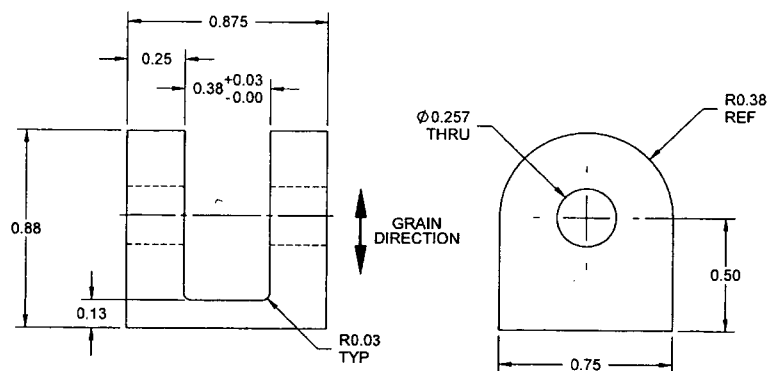
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

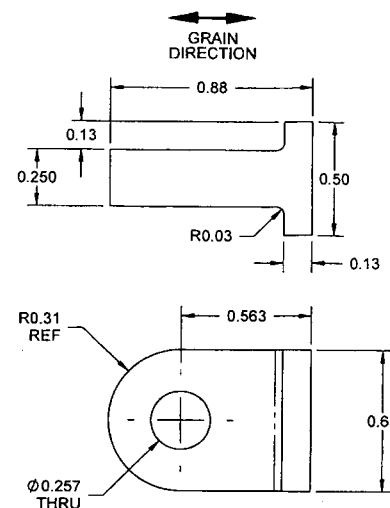
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79413



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX





6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4016	REV. A
MFG. APPR.		TITLE BASKET HINGE	SHEET 2 OF 2
APPROVED			SCALE
DE APPR.			NTS
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